

Work Order ID 162754 -2

162754

Page 1

Monday, June 12, 2017 11:47:22 AM

Item ID: D2230-3

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Mounting Lug

58x
220
220

Split -2-

Stop *NS2*

Start Date: 6/12/2017 Start Qty: 220.00

Cust Item ID:

Required Date: 7/3/2017 Req'd Qty: 220.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: JUN 12 2017 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2230	Rev G
-------	-------

110	Outsource process - Machining	0.00							
110	HAAS CNC VERTICAL MACHINING #1								
Outsource5	Memo	73,920.00							
Outsource process - Machining	Issue P/O to Metec 36680								
	Machine as per dwg								
	C of C is required								

220 JUN 13 2017 DAS 13 9-89

120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120									
Packaging	Memo	4.40							
Packaging	Ensure C of C is attach								

58x 8017-7-19

130	QC6- All purchased or subcontracted products	0.00							
130									
QC	Memo	4.40							
Quality Control									

58 DAS 38 9-89

JUN 21 2017

Work Order ID 162754

162754

Page 2

Monday, June 12, 2017 11:47:22 AM

Item ID: D0230-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mounting Lug
 Start Date: 6/12/2017 Start Qty: 220.00 *220* Cust Item ID:
 Required Date: 7/3/2017 Req'd Qty: 220.00 *220* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo N/A	0.00 DAS 38 9-89 4.40							
--	--	--------------------------------	--	--	--	--	--	--	--

150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo N/A	0.00 DAS 38 9-89 2.20							
---------------------------------------	---	--------------------------------	--	--	--	--	--	--	--

160 *160* Powdercoat Powder Coating	White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum Memo N/A START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 DAS 38 9-89 1.85							
--	---	--------------------------------	--	--	--	--	--	--	--

Work Order ID 162754

Monday, June 12, 2017 11:47:22 AM

162754

Page 3

Item ID: D0230-3

Revision ID:

Item Name: Mounting Lug

Start Date: 6/12/2017 Start Qty: 220.00

Required Date: 7/3/2017 Required Qty: 220.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

NS00040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	2.20				58			DAS 38 9-89
Quality Control									JUL 21 2017
180	Identify as per dwg & Stock Location	0.00							
180									
Packaging	Memo	2.20				58			68-1 9 JUL 31 2017 DAS
Packaging									rd
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	22.00							17/8/2
Quality Control									(Signature)

JUL 31 2017

Picklist Print

Monday, June 12, 2017 11:47:25 AM

Page 1
T

Work Order ID: 162754

162754

Parent Item: D2230-3

D2230-3

Parent Item Name: Mounting Lug

Start Date: 6/12/2017

Required Date: 7/3/2017

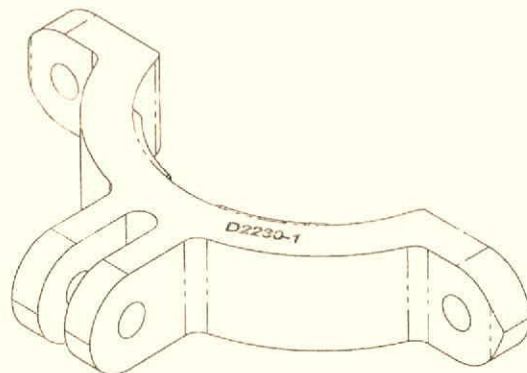
Start Qty: 220.00

Required Qty: 220.00

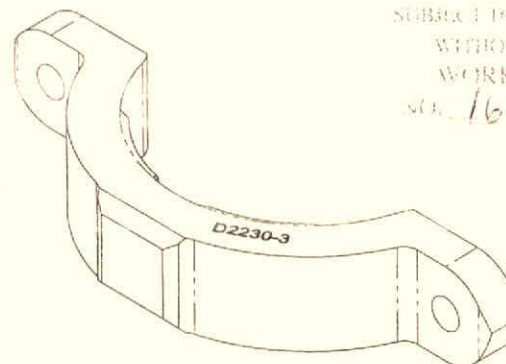
Comments: IPP D00.05.18 Added inspection level 8. and removed P/O for powder coat EC
IPP REV :E NEW FOLIO # 10-05-25 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-3P *D2230-3P* Lug		Purchased	No			110	Each	0.0000	1	220			
								**		58x			
D2423 *D2423* Lug Extrusion		Manufactured	No			110	f	304.4802	0.0683	15.81684			
								**		58x 8017-7-19			
Location Metec 115229 127892 148835 Loc Qty 304.4801737 64 83.2745647 157.203609 Loc Code													

DAS
13
9.89
JUN 13 2017



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

SHOP COPY
RETURN TO
DRAWING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162754M5
1706-12

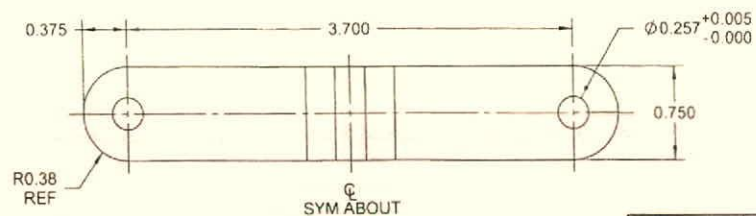
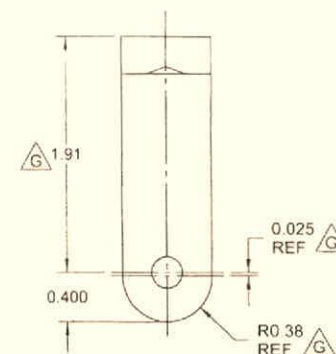
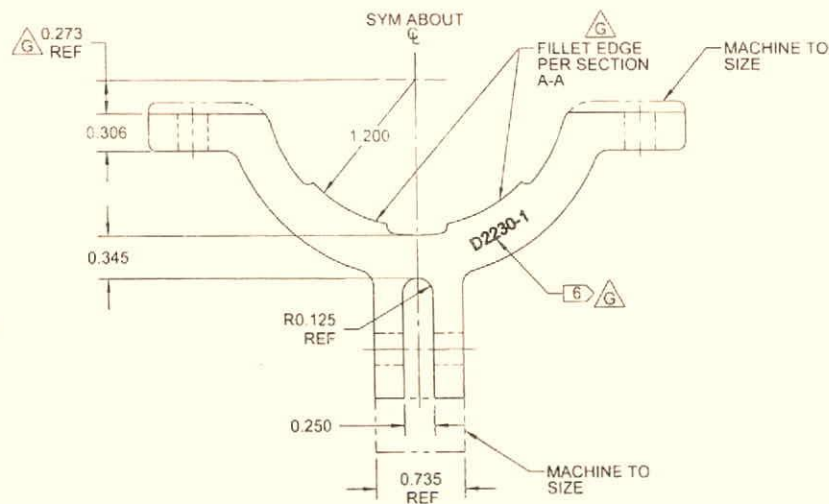
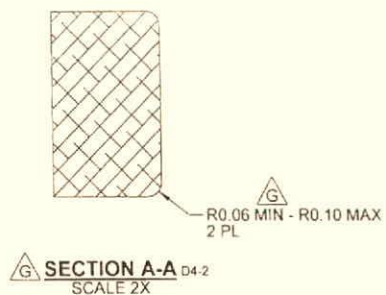
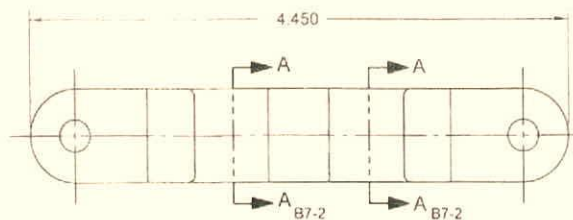
RELEASED
01/06/25



NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

DESIGN	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION	AJS	09.01.16
F	REDESIGN; R1 200 WAS 1 100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY COMMUNICATIONS TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



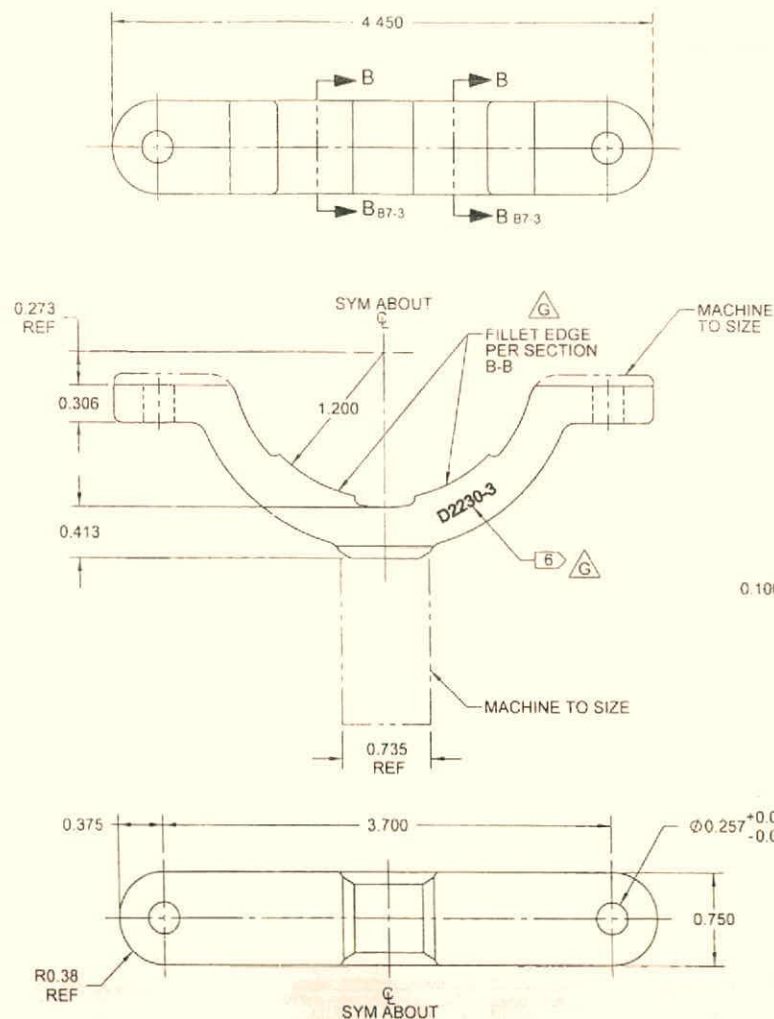
D2230-1 MOUNTING LUG

RELEASED
09/06/75 MT

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D2230	REV. G
MFG. APPR.		TITLE MOUNTING LUG	SHEET 2 OF 3
DE APPR.		SCALE	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPLICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SECTION B-B D4-3
SCALE 2X

R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
01/06/25/14

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36680

Purchase Order Date 6/13/2017

PO Print Date 6/19/2017

Page Number 1 of 4

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

REVISED

Contact Name

Vendor Phone

613 678 3957

Ship To Contact

Ship To Phone

Ship Via:

Dart Truck

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 10

CAD

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2230-3P AS PER DWG D2230 REV. G B162754 ALODINE AND PAINT AS PER QSI005 D2230-3P	Lug	6/20/2017 Yes 6/20/2017 7/14/2017 7/14/2017	FN	162.00 Each 58.00 Each	\$13.80 \$13.80	\$2,235.60 \$800.40
Line Total:							\$3,036.00
2	D3235-1P AS PER DWG D3235 REV. A B162413 ALODINE AND PAINT AS PER QSI005	Lug	6/20/2017 Yes 6/20/2017	FN	50.00 Each	\$15.00	\$750.00
Line Total:							\$750.00

Note:

6/19/2017



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: **21786**
Date: Jul 18, 2017
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 36680	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: Jul 18, 2017

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-3 Mounting Lug alodined and painted as per QSI005 162 stock / 58 ETA July 12, 2017	Each	220	58✓	
D3235-1 Mounting Lug alodined and painted as per QSI005	Each	50		
D3235-1 Mounting Lug alodined and painted as per QSI005	Each	100		
D3394-3 Lug alodined and painted as per QSI005	Each	20		
D3910-1 Crosstube Lug alodined and painted as per QSI005	Each	20		
D3910-3 Crosstube Lug alodined and painted as per QSI005	Each	20		
D3910-5 Crosstube Lug alodined and painted as per QSI005	Each	20		
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				

Received by

8017-7-19

Thank you for your order!

DAS
38
9-89



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

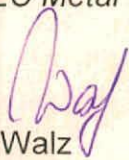
same

Quantity	Part Number	Part Name	Paint Batch #	P.O. Number
58	D2230-3	Mounting Lug	21115	36680

MATERIAL: supplied by DART B115529

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, July 18, 2017

